



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041

Job Sheet 203933



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Due Date: 12/16/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	12/16/19		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		DAS
							Large Fab - 5		43
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	12/16/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		DAS
							QC 9 - 24		24
							QC 9 - 43		9-89
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	12/16/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		DAS
							QC 5 - 22		24
							QC 5 - 24		9-89
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S245198



Part: D3913-041

Job No: 203933

Serial No/Batch: S245198

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/07/20

Plex 11/28/19 1:04 PM Dart.lajeunesse.marie

						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	12/16/19	0.00	0.29	Handfinish - 2 - 1 - B4B	HL 20-1-9
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)-B4B	1 pcs	12/16/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BK 20-01-9
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	12/16/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 20-1-10
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	12/16/19	0.00	0.50	Handfinish - 4 - 1 - B4B	HL 20-1-10
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	

DAS
15
9-89

160 QC 5	1 pcs	12/16/19	0.00	0.00	Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
170 Packaging 3-1 - Stock - B4B	1 pcs	12/16/19	0.00	0.00	QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

DAS
JAN 10 2020 68
9-89

XL 20-1-10

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	12/16/19	0.00 0.00	QC 21 - SA - 21	QAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	8-20

JAN 10 2020

Part Op 100 - Weld per dwg A/R S.S. rod Batch: 41390221 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214321
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5237133 5220643
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5211077
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5224671
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5220145
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5237133
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236847
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5234361
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5231789
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5231158 523314
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5231158
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5238413
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5242694
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5238687
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5240031
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236536
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5236300
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5235320
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	586435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5196544
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5218162
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5241506
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	55	0
	D3913-1	1	5	0
	D3913-15	1	29	0
	D3913-3	1	5	0
	D3913-7	2	10	0
	D3913-9	1	4	0
	D3916-041	2	8	0
	D3916-5	3	17	0
	D4016-1	3	49	0
	D4017-7	3	58	0
	D4017-9	2	20	0
	D4020-11	2	14	0
	D4021-1	3	21	0
	D4034-041	1	2	0
	D4034-043	1	5	0
	D4672-1	2	3	0
	M304EX0.75-16F	32	394	0
	AN3-10A	6	258	0
	D2931	2	605	0
150-Handfinish - 4-1-Assembly-B4B	D4021-5	2	13	0
	MS20600-AD4W3	2	485	0
	MS21042L3	6	1,592	0
	NAS1149F0332P	12	3,807	0
	NAS1149FN832P	2	2,157	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐				Date: _____ Sequence #: _____ QTY Affected: _____ MRB (QS1042) _____																											
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																
Crushing	BOM/Route	Grain Direction	Drawing																																
Cracks	Broken/Damage/Defect	Weld	Finish																																
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																																
Marks/Chatter	Drill Holes	Out of Sequence	Misread																																
Mislabeled	Fit/Function	Off-set/Set-up																																	